

206

Work Order ID 117862

117862

Item ID: 646.9601

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Cutter Assy

Start Date: 5/05/14 Start Qty: ~~2.00~~ 4

2

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 1405-06 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
646.9600	N/C

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

4 0 0 AS
14-6-25

120 0.00

120

Small Fab Memo 0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 125540
exp. date: 5/15

DAS
27
9-89

4 0 0 AS
14-6-25

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

14/6/20

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 117862

117862

Page 2

May-05-14 11:46:21 AM

Item ID: 646.9601 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Cutter Assy
 Start Date: 5/05/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21 - Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

4X DAS 28 JUN 26 2014
 9-89

ML5 14-06-26
 MF
 14-6-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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May-05-14 11:46:20 AM

117862

646 9601

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

110	Each	12.0000	1
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646.9701

AG 14-6-25

Cutter Sub Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
101070		
110642		

CA 9

113350 4

113350 4

91788 5

MF 3

109590 3

110	Each	13.0000	1
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646 981 1

AB 14-6-25

Upper Deflector

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA 13

106775 1

109920 12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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FAULT CATEGORY

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<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

May-05-14 11:46:20 AM

Page 2

Work Order ID: 117862

117862

Parent Item: 646.9601

646 9601

Parent Item Name: Upper Cutter Assy

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

110

Each

5,810.000

3

**

MS21042I 08

Nut

AL 14-6-25

Location

Loc Qty

Loc Code

ST314

3558

123900

58

12

m128401

1500

m128429

2000

ST508

2153

125445

755

m127410

1398

ST509

99

m127304

99

MS27039-08-19

Purchased

No

110

Each

2,256.000

3

**

MS27039-08-19

Screw

AL 14-6-25

Location

Loc Qty

Loc Code

ST506

2256

124309

854

125654

127

12

m127410

275

m127904

1000

NAS1149FN832P

Purchased

No

110

Each

9,830.000

6

**

NAS1149FN832P

Washer

AL 14-6-25

Location

Loc Qty

Loc Code

ST295

470

123185

30

123522

400

123900

40

24

st510

9360

125268

9360

May-05-14 11:46:20 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600	REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: CUTTER ASSY					
APPROVED BY: ENGR <i>P. Brano</i>		MFG <i>Daniel Gomez</i>	QC <i>Walter Lopez</i>	EFFECT: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED SCREW LENGTH.				

117862 MLS
1405-06

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM							CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
							DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE DESIGN PER		NAC
NAC	INITIAL RELEASE	04/30/08	P-DRAVO



1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

	I		8	646.9812	LOWER DEFLECTOR LOW		
		I	7	646.9812	LOWER DEFLECTOR HIGH		
		I	6	646.9811	UPPER CUTTER DEFLECTOR		
A/R	A/R	A/R	5	601.2045	RTV. LOCITE 598		
3	3	3	4	601.1541	LOCKNUT	M52134L20B	
3	3	3	3	601.2765	SCREW	NAS27037-GB19	
6	6	6	?	601.2764	WASHER	JSA3114P-RS32P	
1	1	1	1	646.9701	CUTTER SUB ASSY.		
X	X	X		646.9603	LOWER CUTTER ASSY LOW.		
X	X	X		646.9602	LOWER CUTTER ASSY HIGH		
X	X	X		646.9601	UPPER CUTTER ASSY		
.9603	.9602	.9601	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY							
NEXT ASSEMBLY [S]			PARTS LIST				
646.9500			<div style="text-align: center;">APICAL INDUSTRIES 2808 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300</div>				
			<div style="text-align: right; font-size: large;">CUTTER ASSY</div>				
			<div style="float: left; width: 40%;">OFFICIAL DATE <small>(REVISION)</small> 01-01-09 BY JACKSON J. JACKSON M. BRAYC DRAWING APPROVAL DATE 01-01-09 SCALE COMPACT TWO</div> <div style="clear: both;"></div> <div style="font-size: small; margin-top: 10px;">DRESS OR PART SPECIFIED DIMENSIONS ARE FITTED TOLERANCES ARE: FRACTIONS DECIMALS POSITIVE DECIMALS .0005 ANGLES .5° SURFACE FINISHES 120S FINISH</div>				
			<div style="margin-left: auto; margin-right: auto; border: 1px solid black; padding: 5px; background-color: white;">REV. C.A. CODE DWG NO SCALE NONE REV. M/C</div>				